

Work Order ID 72724

Wednesday, August 10, 2011 8:02:13 AM



Page 1

Item ID: DSK077

Accept



Setup Start



Revision ID:

Stop



Item Name: D2892-1 TURNING DETAIL

Start Date: 8/10/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 8/22/2011 Req'd Qty: 7.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK077	Rev A								
100		0.00							
	MORI SEIKI CNC LATHE LARGE								
Doosan	Memo	0.00							
Doosan Lathe	Turn blank as per Folio FA082 check bore with DT8495								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

7

7

SL 11/9/15

SL 11/9/15

SL 11-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72724

Wednesday, August 10, 2011 8:02:13 AM

Page 2

Item ID: DSK077

Accept

Setup Start

Revision ID:

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Item Name: D2892-1 TURNING DETAIL

Start Date: 8/10/2011 Start Qty: 7.00

Cust Item ID:

Required Date: 8/22/2011 Req'd Qty: 7.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Memo

0.00

0.00

Packaging

Identify and Stock in Kanban Location: MAT 050

SL 11-09-16

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/16
ME
11-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 10, 2011 8:02:21 AM

Page 1

Work Order ID: 72724



Parent Item: DSK077

Parent Item Name: D2892-1 TURNING DETAIL

Start Date: 8/10/2011

Required Date: 8/22/2011

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-003

Manufactured

No

Each

4.0000



Round Billet, 17-4

7

4/18/15

Location

Loc Qty

Loc Code

MAT043

4

60943

3

66960

1

372807

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77724
Description: Turning Detail for D2892-1		Part Number:	DSK077
Inspection Dwg: DSK077 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.524	2.529		2.528	2.528	2.528	2.528	2.529
B	3.702	3.722		3.713	3.712	3.728	3.713	3.712
C	2.814	2.834		3.825	3.824	3.824	3.823	3.823
D	0.718	0.738		-730	-730	-730	-730	-730
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.714	2.734		2.725	2.724	2.724	2.723	2.723
G	2.029	2.049		2.040	2.040	2.040	2.040	2.040
H	3.214	3.234		3.226	3.225	3.225	3.224	3.224
I	0.913	0.933		.918	.918	.918	.918	.918
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.102	.102	.102	.102	.102
L								
M								
N								
O								
P								

Measured by: SA **Date:** 10/2/15

Audited by: SL **Date:** 11-09-16

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SA

88673

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	7724
Description: Turning Detail for D2892-1		Part Number:	DSK077
Inspection Dwg: DSK077	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	3	4	5
Lathe Section								
A	2.524	2.529		2.528	2.529			
B	3.702	3.722		3.713	3.713			
C	2.814	2.834		2.829	2.824			
D	0.718	0.738		0.730	0.730			
E	0.090	0.110		0.101	0.101			
F	2.714	2.734		2.725	2.725			
G	2.029	2.049		2.040	2.040			
H	3.214	3.234		3.224	3.224			
I	0.913	0.933		0.928	0.918			
J	0.022	0.042		0.031	0.031			
K	0.090	0.110		0.102	0.102			
L								
M								
N								
O								
P								

Measured by:	<i>[Signature]</i>	Date:	11/12/15
Audited by:	<i>[Signature]</i>	Date:	11-09-16
Prototype Approval:		Date:	

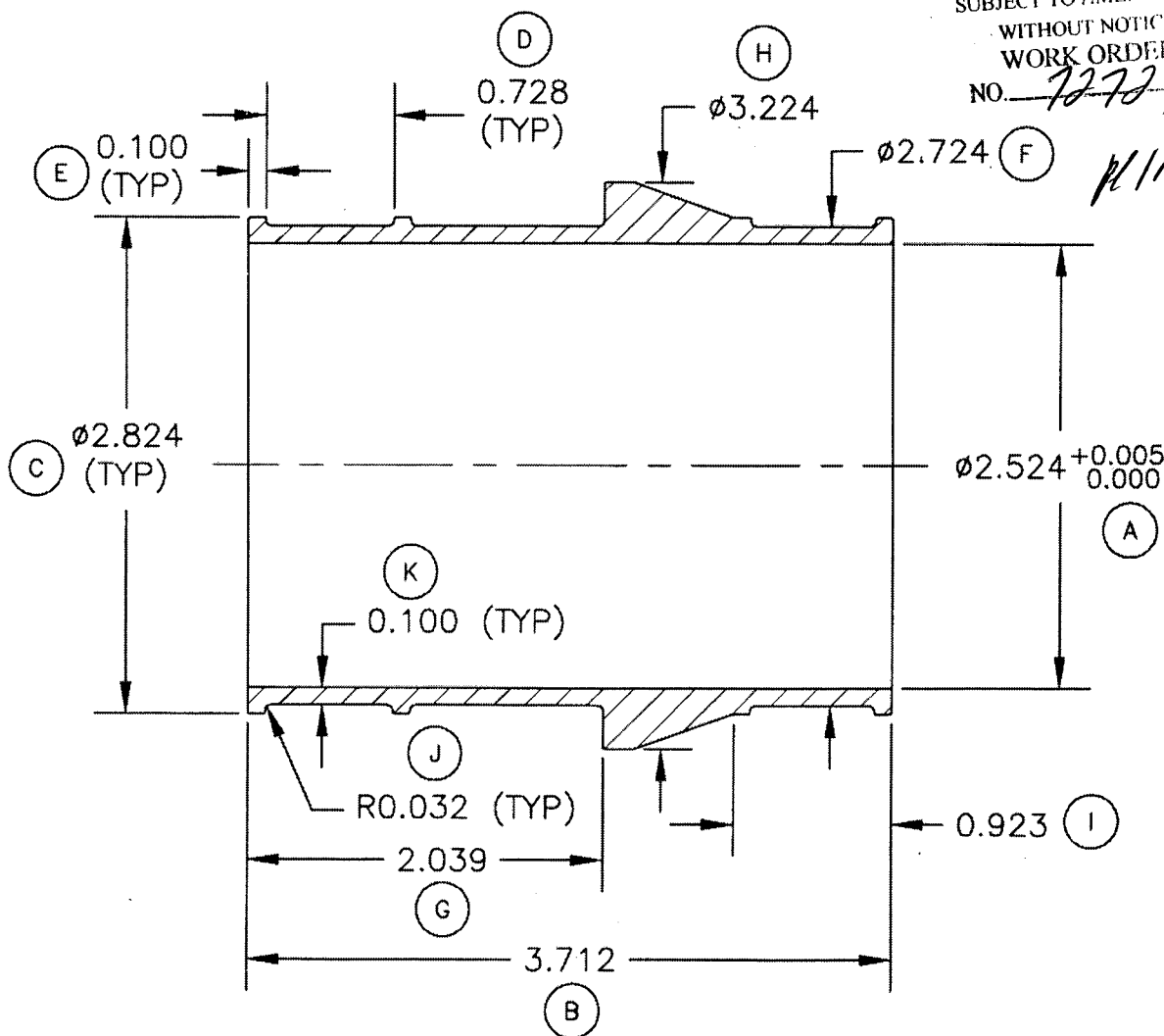
Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 077	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2892-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 [Signature]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72724



D2892-1 TURNING DETAIL

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